

5/24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23492
<b>Description:</b> 206 L/L-1/L-3/L-4 HighGear Web		<b>Part Number:</b>	D2654-7
04.08.17 kg 04.08.17 qf			
<b>Drawing:</b> D2654 Rev. D/EI		<b>Qty:</b>	23

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JP	05.06.06	3
2	METAL	Pick: Qty Part Number Description Batch ✓ 1 D2600-7 Web B2A66	DP	05/6/14	3
3	METAL	Cut D2600-7 to length as per Dwg D2654 (116.00") 04.07.07	DP	05/6/14	3
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	DP	05/6/14	3
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	DP	05/6/14	3
6	METAL	Deburr holes and ends	DP	05/6/14	3
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	DP	05/6/14	3
8	QC	Inspect Level 5	ml	05.06.10	3
9	METAL	Identify and stock	2	05-06-20	3
10	EXPEDITING	Close Work Order 34.46 Cost/part: 37.32	BE	05-06-20	3
			JP	05.06.28	3
			AL	05/06/06	3

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	(B)

**MANUFACTURER RELEASE CERTIFICATION**

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

**RELEASED**  
DM 99.02.19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

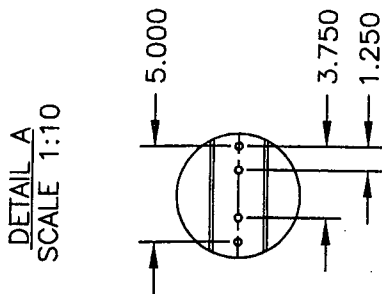
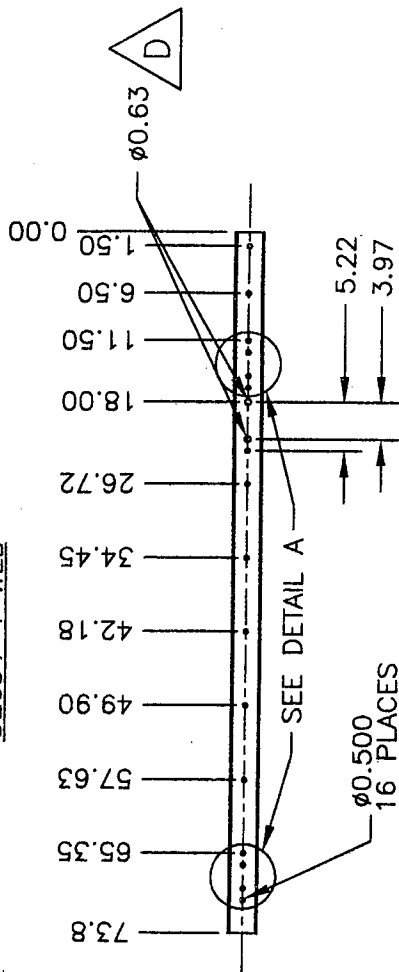
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



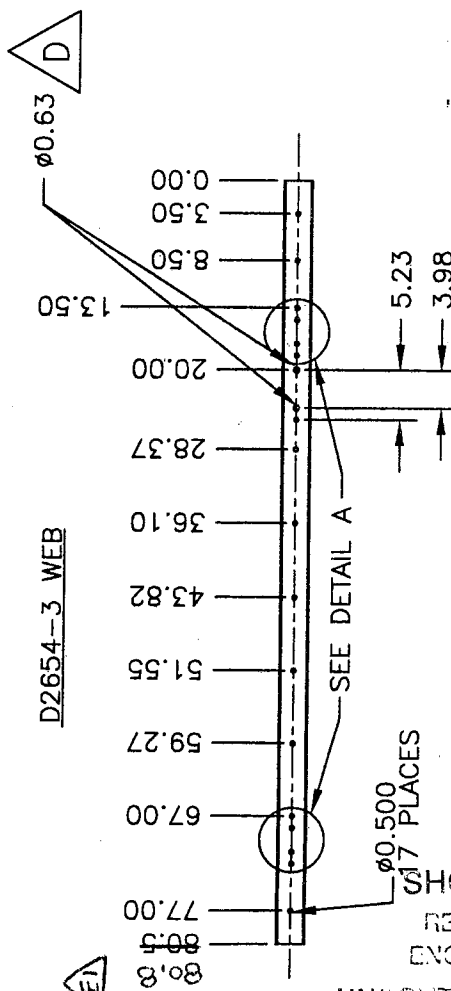
DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>		APPROVED <i>#</i>		DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB		SCALE 1:20	
A	97.03.25		NEW ISSUE		
B	97.06.26		ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29		CHANGED HOLE PATTERN		
D	98.01.15		GHW HOLES CHANGED TO $\phi 0.63$		
E	04.05.26		CHANGE LENGTHS, REFORMAT		
E1	<i>CP</i> <i>#</i>	04.08.04	PER TOOLING; 90.8 WAS 90.5		

RELEASED  
04.06.22

D2654-1 WEB



D2654-3 WEB



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WORK ORDER  
NO. 23492

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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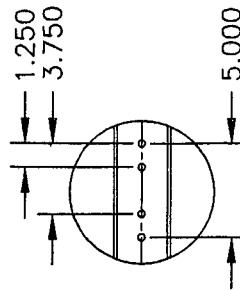
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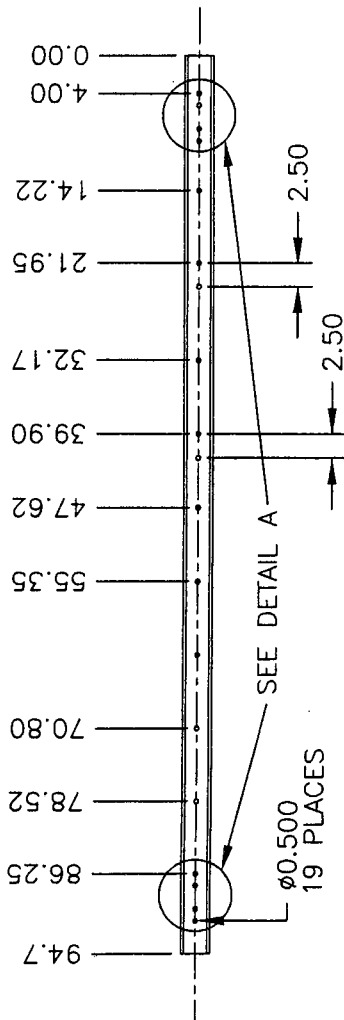
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED  
04.06.22

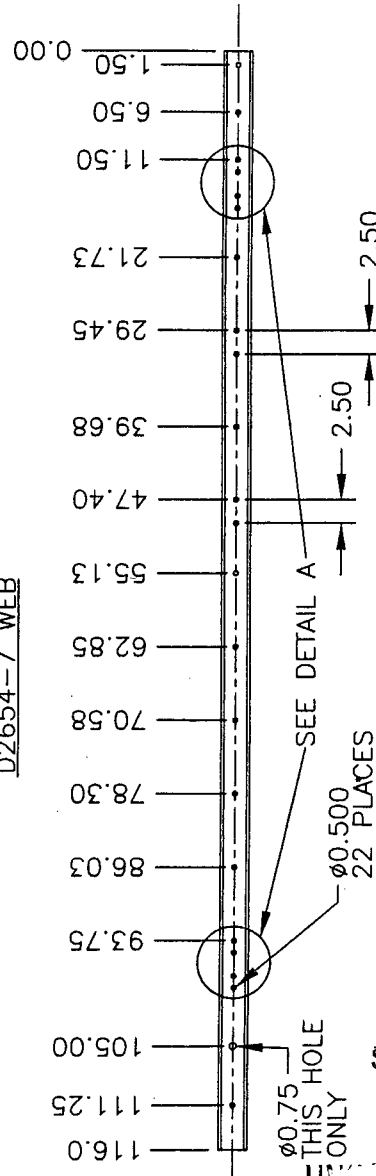
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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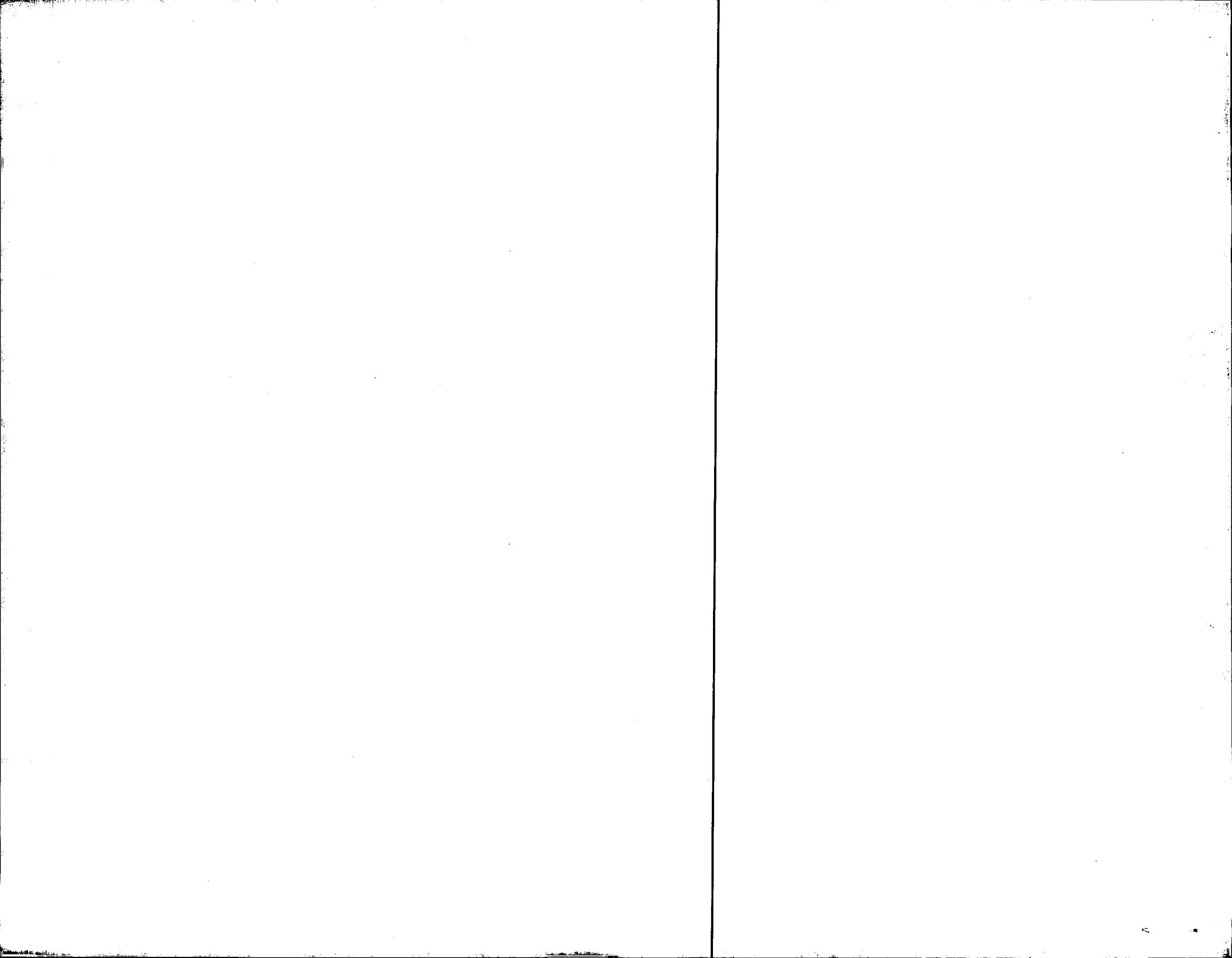
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WORK ORDER

NO. 23492

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 03, 2005  
10:33 am

Work Order No	: 0023492	Department Code:	
Project Name	: D2654-7	Burden Flags	: NNNNNNNN
Project For	: WK524	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2654-7	Invoice Number	:
Description	: 206 I Beam (Web)	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 2	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 06-03-05		
Est Finish Date	: 06-16-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00